

## ABSTRACT

[0083]

A preferred embodiment of a cam for an accumulating conveyor system has a primary cam and a secondary cam that operably rotate about a common axis at substantially the same speed. The primary and secondary cam each have an outer circumferential surface that defines a receiving portion and a cam surface. The receiving portion of the cam is engageable with a cam follower of a shoe for moving the shoe between an upper and lower horizontal run of the conveyor. In another aspect of the present invention, the conveyor system has two sets of primary and secondary cams. One set of primary/secondary cams is positioned at a beginning of the conveyor system, while the other set is positioned at the end of the conveyor system. The primary cams are positioned at opposite corners of the conveyor system. Each cam is configured differently than the other three cams.